

5/20

DART AEROSPACE LTD		Work Order:	23019
Description: Pin Assembly		Part Number:	D3332-043
Dwg: D3332 Rev. A PAGE 1, 3, 4		Qty:	10
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	RJ	05.04.13	10
2	MC	Machine D3332-7 as per Folio FA493 and Dwg D3332 Material: AISI 1018-1025 Ø0.500" Round Bar (M1018-R0.500) Identify for D3332-7 Batch: M16634	JG	05/05/18	10
3	QC2	Inspect parts as they come off the CNC machine Identify as D3332-7	JG	05/05/18	10
4	QC8	Second check	JP	05.18	10
5	MFA	Fabricate D3332-9 as per Dwg D3332 Material: AISI 1018-1025 Ø0.313" Round Bar (M1018-R0.313) Identify as D3332-9 Batch: M16634	JP	05.05.19	10
6	MFA	Assemble and Weld using D3332-041T1 as per Dwg D3332 Pick: Qty Part Number Description Batch 1 D3332-1 Handle B23054 A/R N/A Steel Rod M16961 Identify as D3332-043	JP	05/06/18	10
7	QC5	Inspect work to Step 6	JP	05.06.18	10
8	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 Cover D3332-7 and cover thread only for D3332-9 prior to painting	M	05.06.17	10
9	QC3	Inspect Powder Coat	JP	05.06.17	10
10	ST	Identify and Stock	JP	05/06/17	10
11	AC	Cost / part: 6.56	JP	05/06/22	10
12	DC	Close W/O 6.54 Inspect Level 21	JP	05.06.28	10

Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	

RELEASED
05/05/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

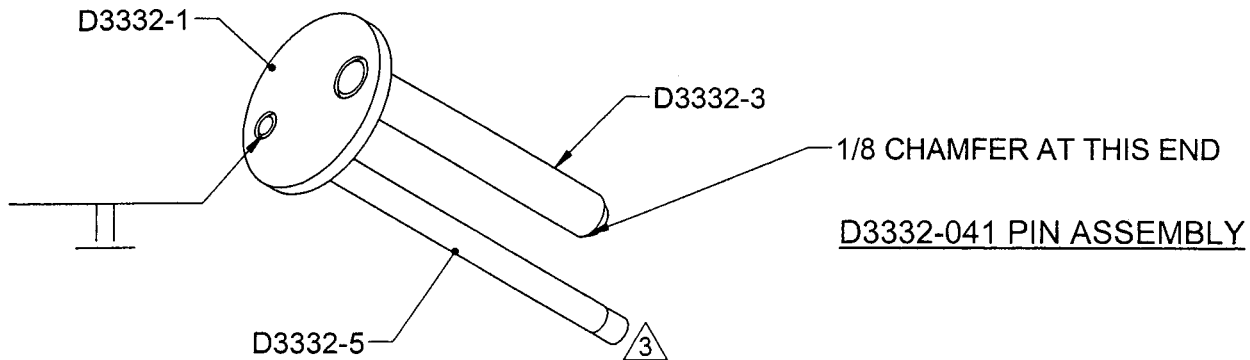
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

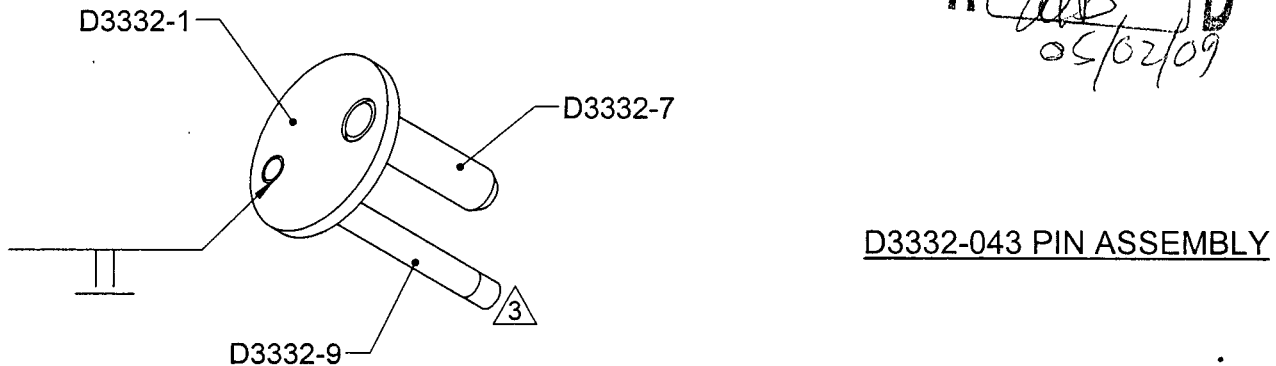
QA: N/C Closed: _____ Date: _____



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3332	REV. A SHEET 1 OF 4
DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:2
A	04.12.14	NEW ISSUE	



RELEASED
[Signature]
05/02/09



NOTES:

- 1) POSITION PARTS USING D3332-041T1
- 2) WELD PER DART QSI 004
- 3) MASK THREADS PRIOR PAINTING
- 4) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3
(COVER THREAD ONLY FOR D3332-5/-9 PRIOR PAINTING)
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.10

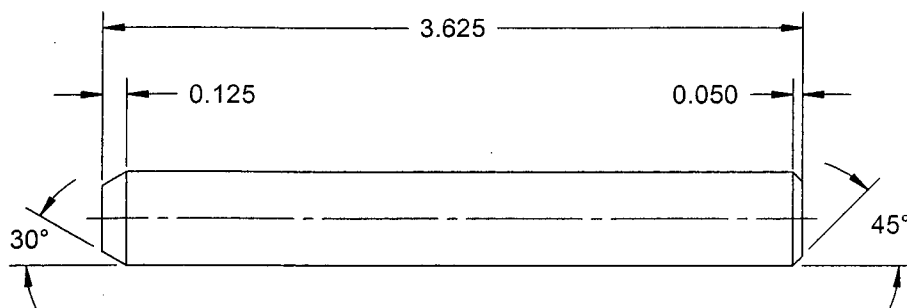
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NO. 23019

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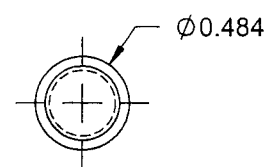
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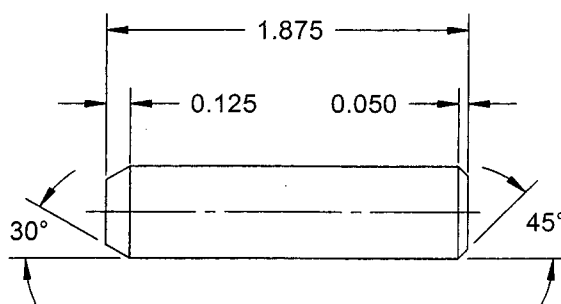
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3332	REV. A SHEET 3 OF 4
DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1



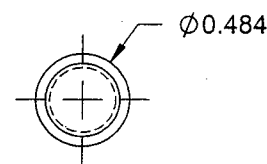
3332-3 PIN



RELEASED
[Signature]
05/02/09



3332-7 PIN



NOTES:

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097 (REF. DART SPEC. M1018R0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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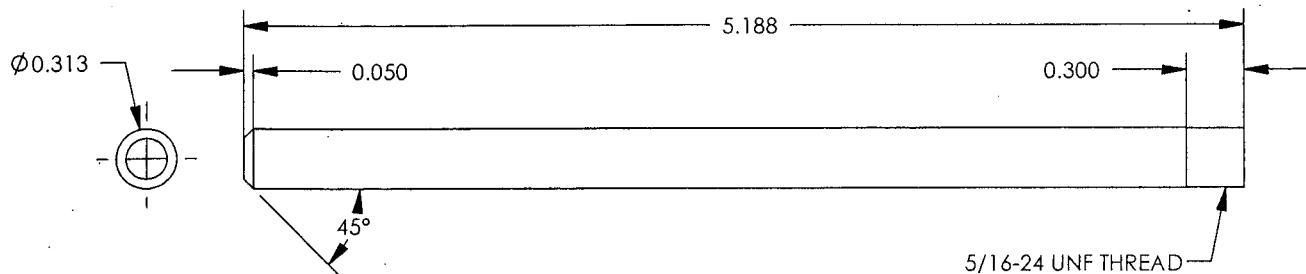
WORK ORDER
NO 23019

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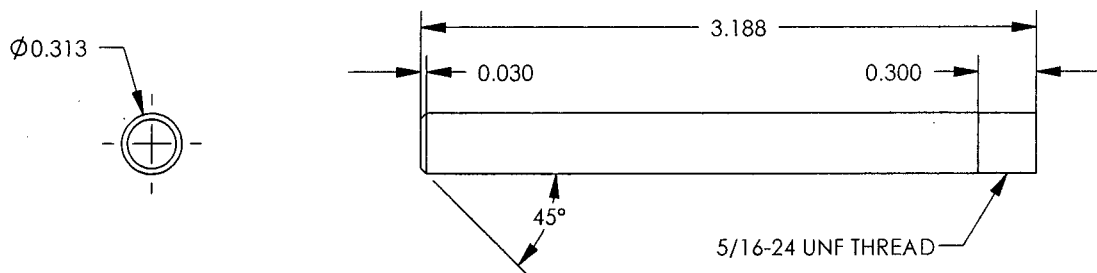
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3332	REV. A SHEET 4 OF 4
DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1



D3332-5 SHAFT



D3332-9 SHAFT

RELEASED
[Signature]
05/02/09

NOTES:

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097
(REF. DART SPEC. M1018-R0.313)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER
NO. 23019

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 12, 2005
02:25 pm

Work Order No : 0023019
Project Name : D3332-043
Project For : WK520
Work Order Type : Main
Main WO Number :
House Part Number : D3332-043
Description : Pin Assembly
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 04-12-05
Est Finish Date : 05-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
=====					
Burden :	0.00	0.00	0.00		
=====					
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00